User: Customer **Estimate Number** Prsht Rev. Previous Run Written By

Thursday, 3/13/2008 10:17:51 AM

Kim Johnston

Process Sheet

: CU-DAR001 Dart Helicopters Services

Job Number

Type

S.O. No. :

: 11924

P.O. Number

: 3/13/2008 This Issue

: NC

First Issue

: 11

: 29934

Checked & Approved By Comment

Est. B

03.03.31 Reformat

: SMALL /MED FAB

KJ/RF

Drawing Name

: TUBE ASSEMBLY

: N/A

: B

Part Number **Drawing Number** : D2003103 : UNDER REVIEW

Project Number

Drawing Revision

Material

Due Date : 3/28/2008

5 Um:

08-03-27

Each

Additional Product

Job Number:



Seq. #:-

1.0

Machine Or Operation:

Description:

6061-T6 Tube .375 x.035W

Comment: Qtv.:

5.5125 f(s) 1.1025 f(s)/Unit Total:

Cut tube Ø 0.375" x 0.035" wall as per template D2003-103T1 (12.00" long)

Material: 6061-T6 WW-T-600/6 (M6061T6T0.375W.035)

1.0828 f(s)/Unit

M26506

Firesleeve-crkl .375IDia

Total:

Qty Part Number Description

5.4138 f(s)

M2650-6

Heat Sleeve

3.0

2.0

D2182045

Comment: Qty.:

Comment: Qty.:

1.0000 Each(s)/Unit

Total: 5.0000 Each(s)

Heat Shrink

Pick:

Qty Part Number 1 D2182-045 Heat shrink

Description

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut 12.38" long Heat sleeve as per Dwg D2003 & heat shrink

Form tube as per template D2003-103T2

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
				ıė										
Part No	•	PAR #: Fault Category:		No DQ										

NCR:			WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Approval								
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector						
			-											
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NOTE: Date & initial all entries

Thursday, 3/13/2008 10:17:51 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: TUBE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D2003103 Job Number: 37913 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 5.0 QC5 Comment: INSPECT WORK TO CURRENT STEP AN8186D Nut 6.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Nut Pick: Description Batch Qty Part Number AN818-6D Nut MS208196D 7.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Sleeve Pick: Part Number Description Batch FF 08-03-27 MS20819-6D Sleeve 8.0 SMALL FAB Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2003 Install Red decal and heat shrink as per PPP D2003-103 QC5 INSPECT WORK TO CURRENT STEP 9:0 Comment: INSPECT WORK TO CURRENT STEP 10.0 PACKAGING RESOURCE #1 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 11.0 QC21 FINAL INSPECTIONAVIO RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Page 2

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W/O:		ę.		1	WORK ORDE	R CHANGES				-				
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Part No): <u> </u>		PAR #:	Fault C	ategory:	NC	R: Yes	No DQ	A :	_ Date:				
			43				QA:	N/C Close	d:	_ Date:				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)											

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Approval Chief Eng							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	iption Sign & Date		Approva QC Inspecto						
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NOTE: Date & initial all entries





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	CHEC	KEP	APPROVED	DRAWING NO. REV. B							
	4	16	1 44	D2003 SHEET 1 OF 2							
	DATE	<i>'</i>		TITLE SCALE							
_	99.0	06.08		206 CABIN HEATER TUBE ASSEMBLIES NTS							
	Α		90.04.09	NEW ISSUE							
	В		99.06.08	UPDATE PER TEMPLATES; ADD P/N'S;							

RELEASED 44.06.08 KED

CC.08.21 GB I could wrong

3 08-05-27

								7	16	intury musing		
P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MS20819-8J SLEEVE	AN818-8.J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/8/7}	VENDOR OR SPEC
D2003-001	T2003-001	5.2	6.00		1			2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-001	T2003-003	7.3	8.12	-		 	 	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62			 	1	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63		 	1	 	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44		 	 		2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33,31	32.38		 	 	 	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-013	12.7	13.54		 		 	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00	 		 	 	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	17.0	16.25		 	 		2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	VW-T-700/6
D2003-017	T2003-017	9.8	10.23		-	2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	
D2003-019 D2003-021	T2003-019	9.6 N/A	2.25			2		 		TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
			5.33				2					WW-T-700/6
D2003-023	T2003-023	4.5				2				TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00				2	-		TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2		<u> </u>			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2		.			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2		<u> </u>			TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25					1	1_	ĴET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13				~~	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00		5 0	ኃ.0}	-V T	2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60		0			2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0								HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0								HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0								HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0]					HEATSLEEVE	M2650-16 CRINKLE-SOF本	STRATOFLEX
D2003-205	T2003-205	9.75	9.60		-			2	_ 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	™ WW-T-700/6
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035/W	ERWW-T-700/6
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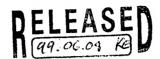
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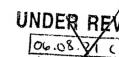
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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANADA	
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DATE		TITLE	SCALE
99 06 08		206 CABIN HEATER TUBE ASSE	MBLIES NTS





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Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

